

CLAIMS

1. A color pigment master batch for blow molding comprising a pigment and a carrier resin, characterized by using as a carrier resin, a thermoplastic elastomer which is a crystalline thermoplastic elastomer having a Vicat softening point higher than a melting temperature of a molding base resin and a crystal melting point higher by 20°C or more than a melting temperature of the molding base resin and in which an MFR (melt flow rate) ratio (MFR of the thermoplastic elastomer/MFR of the molding base resin) to the molding base resin is 5 or more.

2. A color pigment master batch for blow molding comprising a pigment and a carrier resin, characterized by using as a carrier resin, a thermoplastic elastomer which is an amorphous thermoplastic elastomer having a Vicat softening point higher than a melting temperature of a molding base resin and a flow-starting temperature higher by 20°C or more than a melting temperature of the molding base resin and in which an MFR (melt flow rate) ratio (MFR of the thermoplastic elastomer/MFR of the molding base resin) to the molding base resin

is 5 or more.

3. A blow molding method characterized by controlling a temperature of a molding material comprising a molding base resin and the color pigment master batch as described in claim 1 at a tip part of a plasticization extruding device in a blow molding machine so that it is not lower than a Vicat softening point and not higher than a crystal melting point of a thermoplastic elastomer contained in the above master batch, delivering the above molding material controlled in a temperature to an extruding head to heat the above molding material to a higher temperature than a crystal melting point of the thermoplastic elastomer contained in the master batch described above and then extruding it from the extruding head described above to produce a blow-molded article having a grain tone appearance.

4. A blow molding method characterized by controlling a temperature of a molding material comprising a molding base resin and the color pigment master batch as described in claim 2 at a tip part of a plasticization extruding device in a blow molding machine so that it is not lower than a Vicat

softening point and not higher than a flow-starting temperature of a thermoplastic elastomer contained in the above master batch, delivering the above molding material controlled in a temperature to an extruding head to heat the above molding material to a higher temperature than a flow-starting temperature of the thermoplastic elastomer contained in the master batch described above and then extruding it from the extruding head described above to produce a blow-molded article having a grain tone appearance.

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5. A blow-molded article having a grain-tone appearance prepared by blow-molding a molding material comprising as a pigment, 1 to 10 % by weight based on the molding material, of a base color pigment master batch comprising a base color pigment and a carrier resin having a melting temperature which is not higher than a melting temperature of a molding base resin and 0.1 to 5 % by weight based on the molding material, of the color pigment master batch as described in claim 1 or 2 as a pigment.

6. A blow molding method in which a recycled material prepared by crushing or pelletizing again molding burrs obtained in producing the blow-molded

article as described in claim 5 is added in a prescribed amount, wherein a grain-tone pigment having a concentration obtained by deducting an addition percentage of the grain-tone pigment added every hour from a concentration of the residual grain-tone pigment contained in a molded article which finally converges into a fixed value by adding a prescribed amount of the grain-tone pigment every time is supplemented in molding at an initial stage where the recycled material is not added.

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